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D412-698-023
Job Sheet 194541



21
9-50

Part No: D412-698-023

Job Qty: 2 pcs

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 5/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14444*

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		5/14/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S179530



Part: D412 - 698 - 023

Job No: 194541

Serial No/Batch: S179530

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92 - 43 Issue 5, FA406T/C SR014461

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	2 pcs	5/14/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	DAS 46 MAY 09 2019
					QC 4 - 68	46 9-89 MAY 09 2019
130 Packaging 3-1 - Stock - B4B	2 pcs	5/14/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS 21 MAY 09 2019
					Packaging 3 - 36 - B4B	9-89
135 DC - 1 - B4B	2 pcs	5/14/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	2 pcs	5/14/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 MAY 09 2019
					QC 21 - SA - 53	9-89
Part Op 110 - (Pick Kit)						
Descriptions: 120 - (QC4- 100% Inspect kits for completeness)						
130 - (Identify as per dwg & Stock Location:_____)						
135 - (Document Control) Photocopy bluefile & type labels per PPP D412-698-023 CHG003						
140 - (QC21- Final Inspection - Work Order Release)						

DAS
46 MAY 09 2019
DAS
46 MAY 09 2019
9-89

Fg022

DAS
21 MAY 09 2019
9-89

DAS
21 MAY 09 2019
9-89

009697

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop	7 2 pcs (1 ea)	110-Packaging 1 - Pick Kit	51630451
D3594-043	Floor Doubler Assembly, LH	7 2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5161476
D3594-044	Floor Doubler Assembly, RH	7 2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5161480
D3594-5	Doubler	7 2 pcs (1 ea)	110-Packaging 1 - Pick Kit	5161439
D3622-1	Ball Stud	14 4 pcs (2 ea)	110-Packaging 1 - Pick Kit	5160961x13
MS20426AD4-4	Rivet	14 4 Ea (2 ea)	110-Packaging 1 - Pick Kit	5113854
MS21073L5	Anchor Nut	7 2 Ea (1 ea)	110-Packaging 1 - Pick Kit	5123467
NAS1149D0516J	Washer	14 4 Ea (2 ea)	110-Packaging 1 - Pick Kit	5157626

5172048
x1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D3552-11	2	15	0
	D3594-043	2	9	0
	D3594-044	2	12	0
	D3594-5	2	20	0
	D3622-1	4	38	0
	MS20426AD4-4	4	2,266	0
	MS21073L5	2	23	0
	NAS1149D0516J	4	406	0

Part Specifications

Specifications could not be found.

Plex 5/3/19 1:36 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: **G**

Date: 17.11.23